



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

GA
RB 92700-10328-041-PO
Job Sheet 185584



Part No: RB 92700-10328-041-PO

Job Qty: 3 ea

Part Name: Sight Gage Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/30/18

Job Tracking No:

Due Date: 12/14/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RB 92700-10328-041 Rev.A IPP Rev. A 18.10.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	3 pcs	12/14/18	12/14/18	0.00	0.00	Purchasing		<i>GA</i>
110	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		<i>DAS</i>
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC6		61
130	Small Fab	3 pcs	12/14/18	12/14/18	0.00	0.30	Small Fab-2 <i>N/R</i>		9-89
140	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC5 <i>N/R</i>		
150	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3		<i>MCC</i>
160	QC21-FG	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		<i>DAS</i>

Part Op 100 - Issue P/O: *041341* MANUFACTURE RB 92700-10328-041 AS PER DWG Supplier: ARROW TECH MACHINE
Descriptions: WORKS -Certificate of conformity is required
130 - Re-identify as required.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB 92700-10328-041P	Sight Gage Removal Tool	3 Ea (1 ea)	100-Purchasing	<i>5139884</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RB 92700-10328-041P	3	0	0

Part Specifications

Specifications could not be found.

Plex 10/30/18 2:41 PM dart.Lussier.Patrick



Container No: S139885



Part: RB 92700 - 10328 - 041

Job No: 185584

Serial No/Batch: S139885

Revision: A

Inspector:

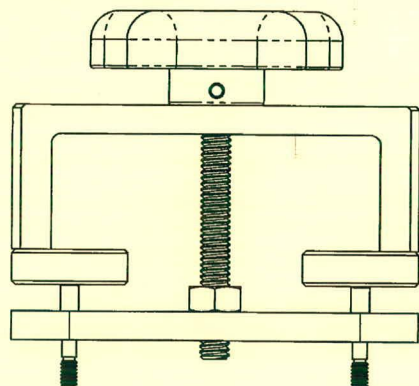
Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 12/21/18

ITEM #	QTY	PART #	PART TITLE
-1	1	RB 92700-10328-041-1	REACTOR
-2	1	RB 92700-10328-041-2	KNOB ASSY
-5	1	RB 92700-10328-041-5	PLATE ASSY
-7	2	RB 92700-10328-041-7	HANDLE
8	1	McMaster#94804A029 OR EQUIV	SS HEX NUT 1/4"-20

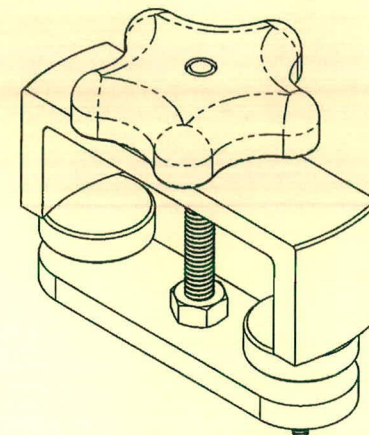
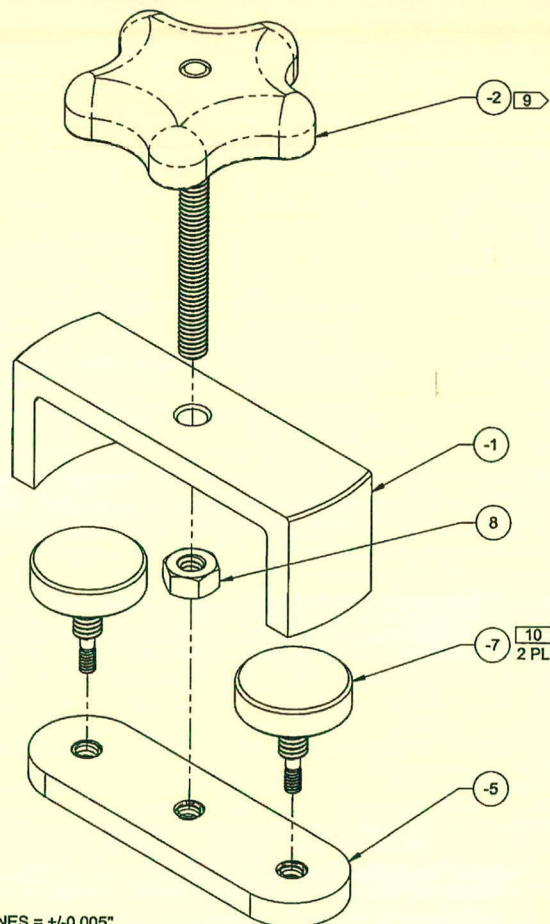


RB 92700-10328-041 SIGHT GAGE REMOVAL TOOL

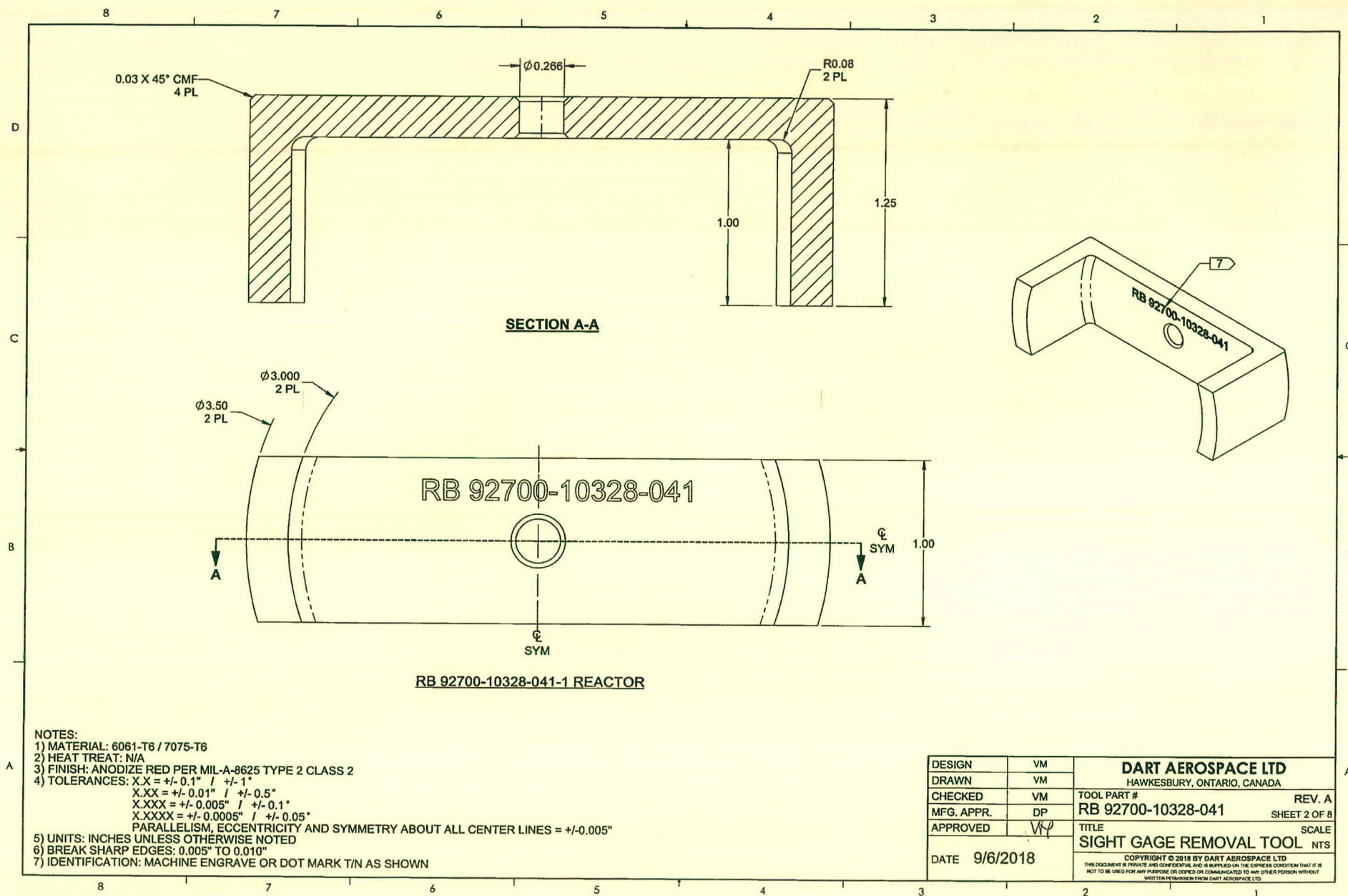
11

NOTES:

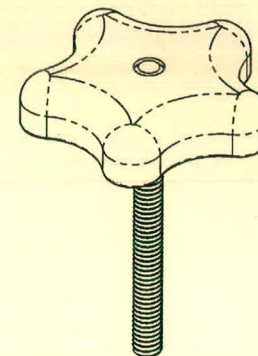
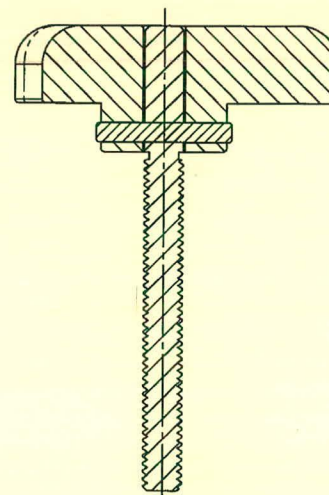
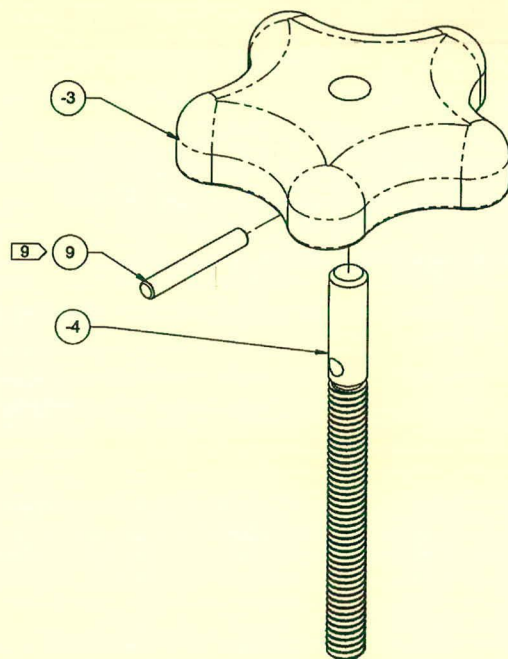
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
X.XX = $\pm 0.01"$ / $\pm 0.5"$
X.XXX = $\pm 0.005"$ / $\pm 0.1"$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEM -2 THEN ASSEMBLE WITH ITEM 8 AND ITEM -5
- 10) APPLY LOCTITE NICKEL BASED ANTI SEIZE ON THREADS OF ITEMS -7 THEN ASSEMBLE WITH ITEM -5
- 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG



A	NEW ISSUE	18-613	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 1 OF 8
APPROVED	VM	TITLE	SCALE
		SIGHT GAGE REMOVAL TOOL	NTS
DATE	9/6/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR OUPRIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



ITEM #	QTY	PART #	PART TITLE
-3	1	RB 92700-10328-041-3	FIVE ARM KNOB MODIFIED
-4	1	RB 92700-10328-041-4	SCREW
9	1	McMaster#98380A474 OR EQUIV.	DOWEL PIN SS 1/8" DIA. x 7/8" LG.

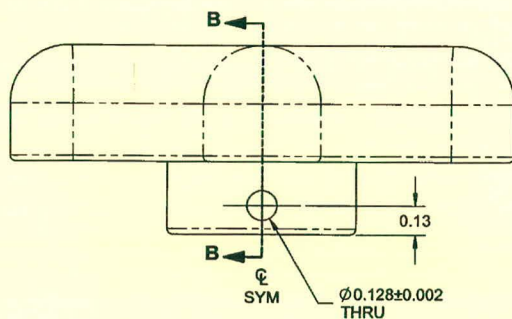


RB 92700-10328-041-2 KNOB ASSY

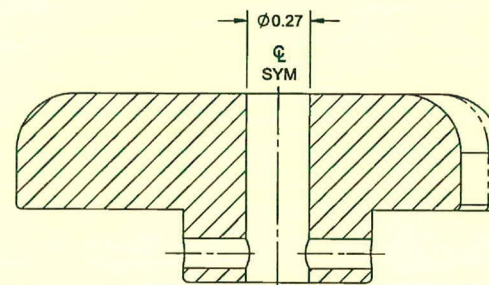
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN
- 9) APPLY LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEM 9 WITH ITEM -4 AND REMOVE EXCESS

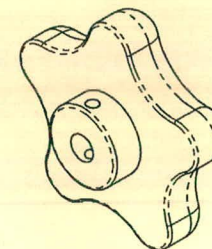
DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 3 OF 8
APPROVED	VM	TITLE	SCALE
DATE 9/6/2018		SIGHT GAGE REMOVAL TOOL	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



RB 92700-10328-041-3 FIVE ARM KNOB MODIFIED



SECTION B-B



NOTES:

1) MATERIAL: McMaster#59625K21 OR EQUIV

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1"$
 X.XX = $\pm 0.01"$ / $\pm 0.5"$
 X.XXX = $\pm 0.005"$ / $\pm 0.1"$
 X.XXXX = $\pm 0.0005"$ / $\pm 0.05"$

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 4 OF 8
APPROVED	VM	TITLE	SCALE
DATE 9/6/2018		SIGHT GAGE REMOVAL TOOL	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RB 92700-10328-041-4 SCREW

NOTES:

1) MATERIAL: 17-4PH-H900 STAINLESS STEEL

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1"

X.XX = +/- 0.01" / +/- 0.5"

X.XXX = +/- 0.005" / +/- 0.1"

X.XXXX = +/- 0.0005" / +/- 0.05"

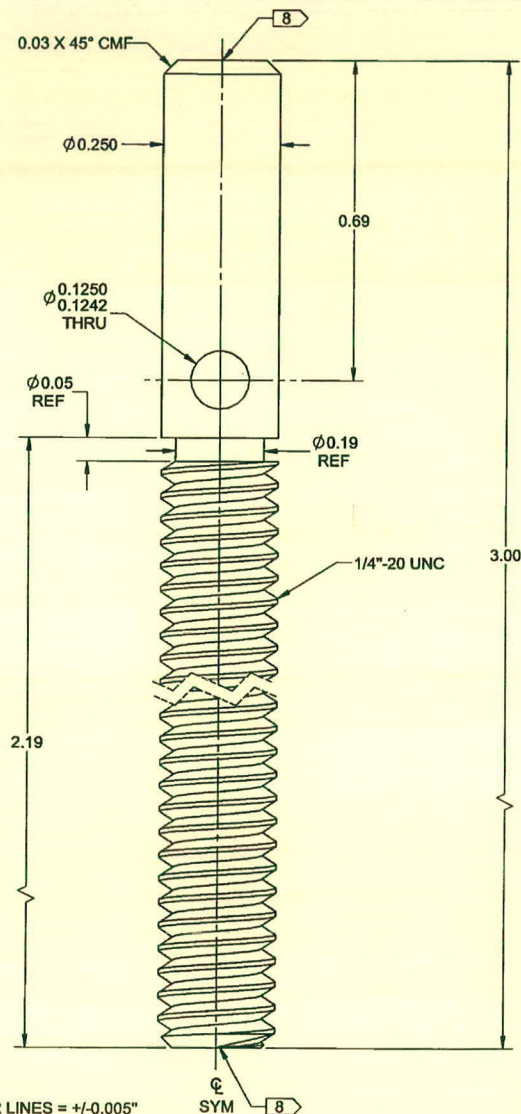
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

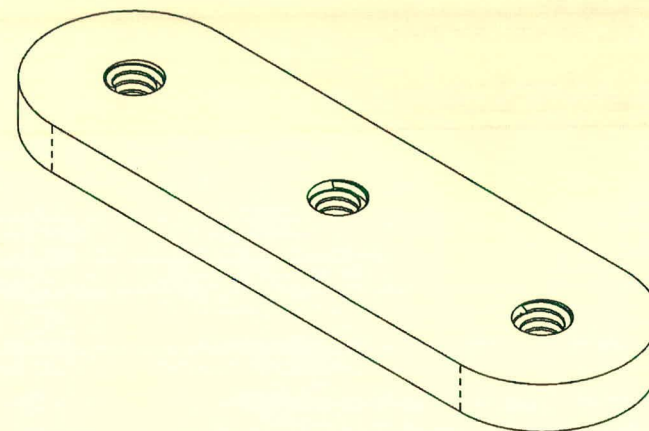
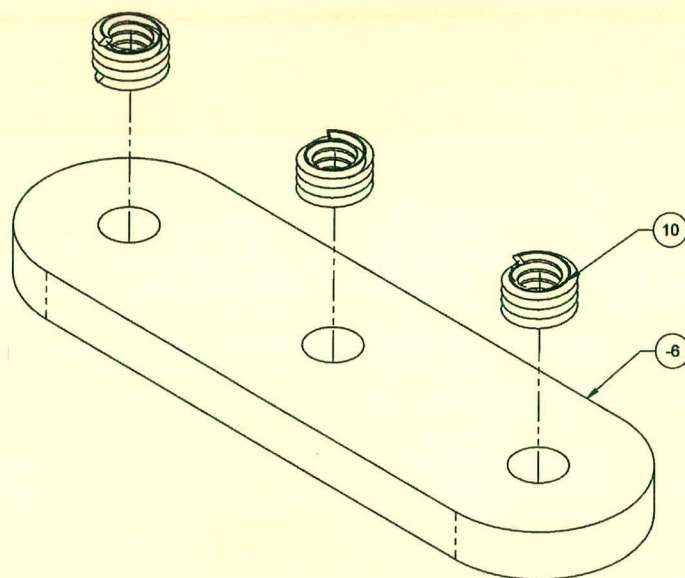
7) IDENTIFICATION: N/A

8) CENTER DRILL IS ACCEPTABLE



DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 5 OF 8
APPROVED	VP	TITLE	SCALE
		SIGHT GAGE REMOVAL TOOL	NTS
DATE	9/6/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM #	QTY	PART #	PART TITLE
-6	1	RB 92700-10328-041-6	PLATE
10	3	FASTENAL#0159876 OR EQUIV	SS HELICOIL 1/4"-20 x 1/4" LG.

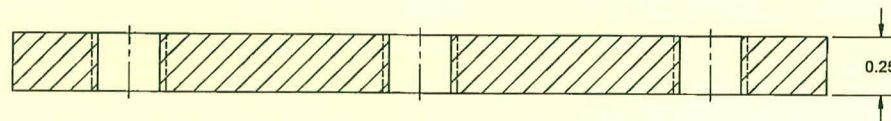
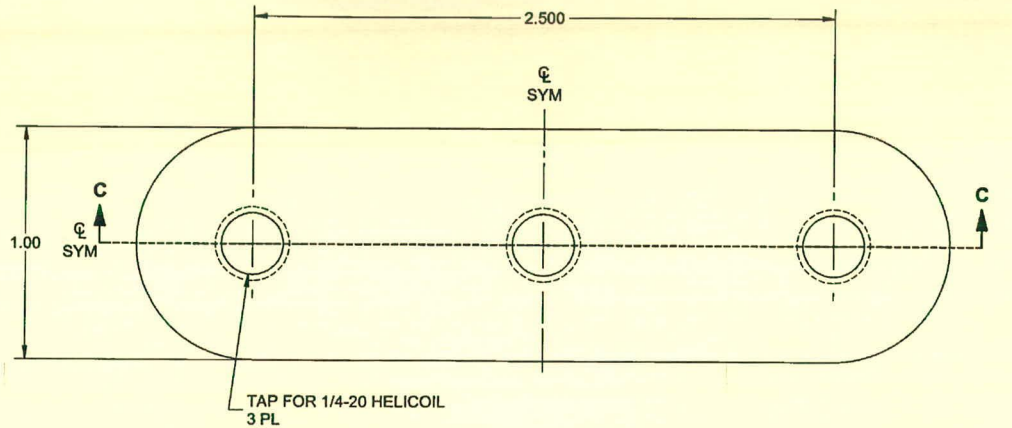


RB 92700-10328-041-5 PLATE ASSY

NOTES:

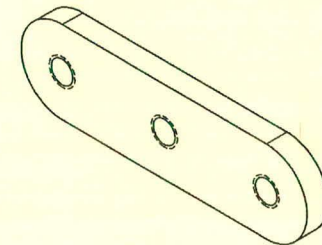
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = $\pm 0.1"$ / $\pm 1^\circ$
X.XX = $\pm 0.01"$ / $\pm 0.5^\circ$
X.XXX = $\pm 0.005"$ / $\pm 0.1^\circ$
X.XXXX = $\pm 0.0005"$ / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $\pm 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) ASSEMBLE AS SHOWN

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 6 OF 8
APPROVED	VM	TITLE	SCALE
DATE 9/6/2018		SIGHT GAGE REMOVAL TOOL	NTS
COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



SECTION C-C

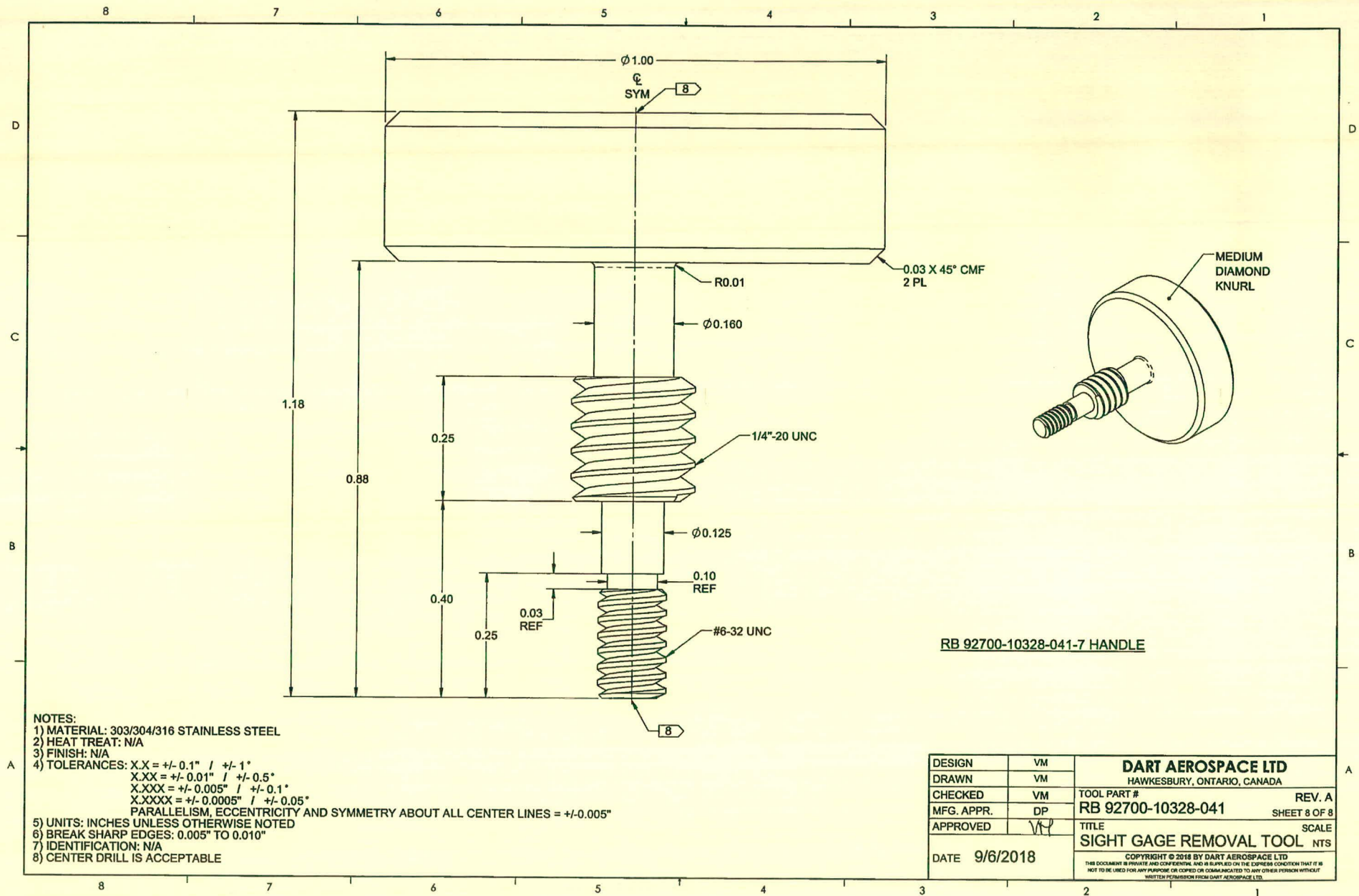
RB 92700-10328-041-6 PLATE



NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
 X.XX = +/- 0.01" / +/- 0.5"
 X.XXX = +/- 0.005" / +/- 0.1"
 X.XXXX = +/- 0.0005" / +/- 0.05"
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VM		
CHECKED	VM	TOOL PART #	REV. A
MFG. APPR.	DP	RB 92700-10328-041	SHEET 7 OF 8
APPROVED	VLP	TITLE	SCALE
		SIGHT GAGE REMOVAL TOOL	NTS
DATE	9/6/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041341**

Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

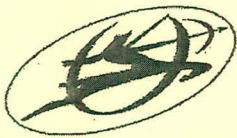
PO No: PO041341
PO Date: 10/12/18
Due Date: 12/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Belanger, NatashaPhone:

Ship To:

Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1		RB 92700-10333-041-4P			Engine Drive Shaft Removal Tool Assy REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,450.00/Ea	\$4,350.00
Line Item Note SIOP													
2	185583	RB 92700-10300-041-1P			Seal Installation Tool REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,098.00/Ea	\$3,294.00
Line Item Note SIOP													
3	185584	RB 92700-10328-041P			Sight Gage Removal Tool REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$627.00/Ea	\$1,881.00
Line Item Note SIOP													
4	185585	RB 92700-10308-041-4P			Input Module Seal Installer Assembly REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$1,856.00/Ea	\$5,568.00
Line Item Note SIOP													
5	185613	RB 92700-10750-101P			Torque Adapter REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$233.00/Ea	\$699.00
Line Item Note SIOP													
6	185614	RB 92700-10750-102P			Input Module Wrench REV A	Firmed	-	12/21/18	3 Ea	0 Ea	3 Ea	\$145.00/Ea	\$435.00
Line Item Note SIOP													

Plex 12/20/18 10:08 AM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 1 OF 2

Date: 12/14/2018
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

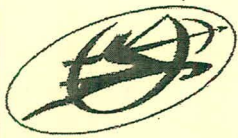
Qty	Item	Part No.
3 ✓	SEAL INSTALLATION TOOL	RB 92700-10300-041 - 1
3 ✓	PLATE ASSEMBLY	RB 92700-10303-041 - 4
3 ✓	WRENCH ASSEMBLY	RB 92700-10303-041 - 6
3 ✓	TGB & IGB SEAL INSTALLER ASSEMBLY	RB 92700-10305-041 - 4
2 ✓	TR NUT WRENCH	RB 92700-10307-041 ✓
3 ✓	TAIL BLADE WRENCH (DE-ICE) WELDMENT	RB 92700-10309-042 ✓
3 ✓	TORQUE REACTOR	RB 92700-10314-101 ✓
3 ✓	SIGHT GUAGE REMOVAL TOOL	RB 92700-10328-041 ✓
3 ✓	ENGINE DRIVE SHAFT REMOVAL TOOL ASS	RB 92700-10333-041 ✓
3 ✓	BEARING SPANNER WRENCH	RB 92700-10340-101 ✓
3 ✓	SEAL REMOVAL ASSEMBLY	RB 92700-10350-041 - 5
3 ✓	BEARING ALIGNMENT TOOL	RB 92700-10356-041 ✓
3 ✓	TORQUE ADAPTER	RB 92700-10750-101 ✓
3 ✓	INPUT MODULE WRENCH	RB 92700-10750-102 ✓
3 ✓	RIG PLATE SCREW	RB 92700-10400-041-6 ✓
3 ✓	PIT STOP GUAGE	RB 92700-10400-041-7 ✓
3 ✓	RIG GUAGE PLATE (SPARES)	RB 92700-10400-041-9 ✓

DAS
61
9-89

Received by: _____
Packaged by: _____
Checked by: _____

Thank You

78



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 2 OF 3

Date: 12/14/2018
PO Ref: 041341
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	TRS LEFT STOP GUAGE	RB 92700-10400-041-11 ✓
3 ✓	RH MID GUAGE	RB 92700-10400-041-12 ✓
3 ✓	TR MID BLOCK	RB 92700-10400-041-13 ✓
3 ✓	ROLL STOP GUAGE	RB 92700-10400-041-14 ✓
3 ✓	COLL STOP GUAGE	RB 92700-10400-041-16 ✓
3 ✓	LIMITER GUAGE	RB 92700-10400-041-18 ✓
3 ✓	LH MID GUAGE	RB 92700-10400-041-20 ✓
3 ✓	FWD MID GUAGE	RB 92700-10400-041-22 ✓
3 ✓	RH MID GUAGE	RB 92700-10400-041-24 ✓
3 ✓	MIX PIN P / C / R	RB 92700-10400-041-26 ✓
3 ✓	MIX PIN YAW	RB 92700-10400-041-28 ✓
153 ✓	RIG PIN ASSEMBLY	RB 92700-10400-041-30 ✓
3 ✓	BOOST COL LOW	RB 92700-10400-041-33 ✓
3 ✓	3.5" PIN ASSEMBLY	RB 92700-10400-041-36 ✓
3 ✓	9" PIN ASSEMBLY	RB 92700-10400-041-39 ✓
3 ✓	16" PIN ASSEMBLY	RB 92700-10400-041-41 ✓
3 ✓	COCKPIT - RIG PINS <i>Missing CFC</i>	RB 92700-10400-041-43 ✓

Received by: _____

Packaged by: *ADP*

Checked by: *Q.F.*

Thank You



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 356

PAGE 3 OF 3

Date: 12/14/2018
PO Ref: 041341 ✓
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
3 ✓	5" PIN ASSEMBLY	RB 92700-10400-041-45 ✓
3 12 ✓	BOOST MID PIN	RB 92700-10400-041-49 ✓
3 ✓	ROTOR HEAD - CROSS BAR	RB 92700-10400-041-52 ✓
3 ✓	CYCLIC - RIG BLOCK ASSEMBLY	RB 92700-10400-041-63 ✓
3 ✓	ROTOR HEAD - RIG PLATE	RB 92700-10400-041-64 ✓

Received by: _____

Packaged by: HR

Checked by: CP

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:041341 ✓

Dated: 12/14/2018

Our Order / Job No:041341-3AWT

Order Qty:3 ✓

Part Name:SIGHT GAGE REMOVAL TOOL

Part Number: RB 92700-10328-041 ✓

DAS
61
9-89

Lot Size:N/A

Ship Date: 12/14/2018

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number:RB 92700-10328-041

Rev:A

Material Size and Type: -1,-6/6061-T6 ALUM.; -4/ 17-4PH H900 SS; -7/304 SS

Material Specifications: ALUM: ASTM B209; -4 SS: ASTM A479; -7 SS: ASTM 5640, ASTM A314, ASTM 582

Heat Treatment: N/A

Plating/Finish:RED ANODIZE:MIL-A-8625F, TYPE 2 CLASS 2

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 12/17/18

Signed: _____

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com

